

WHAT IS CLAIMED IS:

- Sub R1/ 1. A cutting tool for cutting a workpiece comprising:
- 5 a tool body having an outer surface thereon and a central axis therein and including at least a first and second spiraling flute in the outer surface, each flute including a plurality of inserts secured therein to define an axial rake angle, wherein the axial rake angle of the inserts varies between
- 10 flutes and within each flute.
2. The cutting tool of claim 1 wherein all of the inserts on the entire tool body are identical.
3. The cutting tool of claim 1 wherein the tool body includes three spiraling flutes, wherein each
- 15 spiraling flute has a first, second and third axial rake angle.
4. The cutting tool of claim 3 wherein all of the inserts on the entire tool body are identical.
5. The cutting tool of claim 4 wherein each
- 20 insert has an actual length longer than the cutting edge, and the actual lengths of adjacent inserts in any flute do not circumferentially overlap.
6. The cutting tool of claim 1 wherein the inserts each have a cutting edge and the cutting edges
- 25 on adjacent inserts in any flute do not circumferentially overlap such that cutting using the cutting tool having at least two flutes with differing axial rake angles results in an all effective cut.
7. The cutting tool of claim 1 wherein the
- 30 inserts each have a cutting edge and the cutting edges on inserts with differing axial rake angles have differing cutting edge lengths.

8. A cutting tool comprising:

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